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10. (Amended) The method of Claim ¹9 wherein the adhesive patch station includes a supply of patch material and an applicator operatively coupled with the supply of patch material so as to apply adhesive to selected areas of either one or both of the web and patch material to apply patch material to selected areas of the web.

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11. (Amended) The method of Claim ²10 wherein the patch material comprises glassine paper.

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12. (Amended) A method for producing multiple die-cut business forms, said method comprising the steps of:

providing a continuous web of stock paper;

extending the web through at least one printing station;

printing on selected areas of the web with the printing station;

extending the web from the at least one printing station through an adhesive patch station;

applying an adhesive patch to selected areas of the web by applying adhesive to selected areas of either one or both of the web and patch material with the adhesive patch station;

extending the web from the adhesive patch station through at least one die cutting station; and

cutting selected portions of the web contiguous with the adhesive patch with multiple die cuts with the at least one die cutting station.

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13. (Amended) The method of Claim ⁴12 wherein the adhesive patch station includes a supply of patch material and an applicator operatively coupled with the supply of patch material so as to apply adhesive to selected areas of either one or both of the web and patch material to apply patch material to selected areas of the web.

14. (Amended) The method of Claim ⁵13 wherein the patch material comprises glassine paper.

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15. (New) A method for producing printed business forms with at least one integrated, removable portion on a press from a source of stock paper comprising:

supplying a roll of stock paper at a supply station

unwinding the roll of stock paper to supply a continuous web of paper to run through the press;

receiving the continuous web of paper by at least one printing press station;

printing indicia on at least a first selected area of the continuous web of paper as the at least first selected area of the continuous web of paper passes through the at least one printing press station;

receiving the continuous web of paper by at least one adhesive patch station;

applying adhesive to a second selected area of either one or both of the continuous web of paper and patch material and applying selected areas of the patch material to selected areas of the web by the at least one adhesive patch station;

receiving the continuous web of paper by at least one die cutting station;

die cutting at least a third selected area of the continuous web of paper, the at least third selected area being contiguous with the patch material as the continuous web of paper pass through the at least one die cutting station in order to produce a removable portion of the continuous web of paper to form business forms with at least one removable, integrated portion; and

receiving the continuous web of paper by at least one finishing station to process the continuous web into a preselected output configuration for the business forms.